

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027190**Date Inspected:** 20-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai**CWI Name:** Wai Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

FCAW welding of fillet welds located on Barrier Rails components identified as E5-SB5-007 weld number(s) 006~031. Welder is identified as welder no. 045221. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

FCAW welding of fillet welds located on Barrier Rails components identified as E5-SB1-014 weld number(s) 006~031. Welder is identified as welder no. 201853. The welding variables recorded by ZPMC QC identified as Wai Tao appeared to comply with applicable WPS(s) WPS-B-T-2132-3 & WPS-B-T-2133.

Bay Number 2

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 099. Welder is identified as welder no. 068554. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

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FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 103. Welder is identified as welder no. 066236. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 021. Welder is identified as welder no. 067877. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3343-001 weld number(s) 027. Welder is identified as welder no. 045280. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

Bay Number 3

FCAW welding of fillet weld joint(s) located on lift 14 OBG longitudinal diaphragm identified as LD3040-001 weld number(s) 112,113, 118, & 119. Welder is identified as welder no. 208035. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on lift 14 OBG longitudinal diaphragm identified as LD3041-001 weld number(s) 137~140. Welder is identified as welder no. 206623. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of fillet weld joint(s) located on lift 14 OBG longitudinal diaphragm identified as LD3041-001 weld number(s) 195,196, 199, & 200. Welder is identified as welder no. 217805. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2132-3.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 255. Welder is identified as welder no. 044830. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 022. Welder is identified as welder no. 050242. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 228. Welder is identified as welder no. 055564. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 108. Welder is identified as welder no. 062782. The welding variables recorded by ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

FCAW welding of complete joint penetration weld joint(s) located on lift 14 OBG floor beam identified as FB3286-001 weld number(s) 104. Welder is identified as welder no. 066359. The welding variables recorded by

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ZPMC QC identified as Wai Tao. appeared to comply with applicable WPS(s) WPS-B-T-2233-TC-U5-F.

Bay Number 4

No contract work being performed in this bay today.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Rene	Quality Assurance Inspector
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Reviewed By:	Levell,Bill	QA Reviewer
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